

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006736**Date Inspected:** 07-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhong An Liu, Tu Jun, Li Lei, Yocum			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Tower and OBG Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 5

This QA Inspector, George Goulet, proceeded to Bay 5 in response to a ZPMC notification of witness inspection #2974 for MT inspection as follows:

This QA Inspector, George Goulet, performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as 21TR4-003. The weld designations reviewed are as follows: 001~008.

This QA Inspector, George Goulet, performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as 21TR4-004. The weld designations reviewed are as follows: 001~008.

This QA Inspector, George Goulet, performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as 21TR4-001. The weld designations reviewed are as follows: 001~008.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector, George Goulet, performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as 21TR4-002. The weld designations reviewed are as follows: 001~008.

This QA Inspector, George Goulet, performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as 21TR3-001. The weld designations reviewed are as follows: 001~008.

This QA Inspector, George Goulet, performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as 21TR3-002. The weld designations reviewed are as follows: 001~008.

This QA Inspector, George Goulet, performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as 21TR1-001. The weld designations reviewed are as follows: 001~008.

This QA Inspector, George Goulet, performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as 21TR1-002. The weld designations reviewed are as follows: 001~008.

Bay 6

This QA Inspector, George Goulet, proceeded to Bay 5 in response to a ZPMC notification of witness inspection #2963 to perform MT inspection as follows:

This QA Inspector, George Goulet, performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as SP201-010. The weld designations reviewed are as follows: 001~012.

Bay 10

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 10:

FCAW welding, using the northwest gantry, of weld joints NSD1-FASA3-1G/G-10, 11, 42, 43 located on PCMK north tower, lift 3, skin A. Welders were identified respectively as 048378, 053869, 040345, 048784. ZPMC QC was identified as CWI Zhong An Liu (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-Tc-P5-F. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Ma Zhen Yi.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

FCAW welding of weld joint SSD1-FDSA3-1C/C-28 located on PCMK south tower, lift 3, skin D. Welder was identified as 040338. ZPMC QC was identified as CWI Tu Jun (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Li Peng Fei, who was not a CWI. The welding variables recorded by QC2 and his assistant appeared to comply with WPS-B-T-4331-Tc-P4-F.

Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Yang Yi Heng.

Bay 11

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 11:

Fitting and SMAW tack welding of weld joints WSD1-FASA3-2B/C-52A, 52B located on PCMK west tower, lift 3, skin A. Welders were identified respectively as 255865, 206195. ZPMC QC was identified as CWI Li Lei (QC3). Assisting QC3 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Tao Lu Hai, who was not a CWI. The welding variables recorded by QC3 and his assistant appeared to comply with WPS-B-P-2212-Tc-U5b.

Fitting and SMAW tack welding of weld joint ESD1-ESTL34B/K-81B located on PCMK east tower, lift 3, skins A to B. Welder was identified as 203787. ZPMC QC was identified as CWI You Qi Guo (QC4). Assisting QC4 at this location and appearing to be monitoring the welding and recording data was ZPMC CAWI Liu Dao Feng. The welding variables recorded by QC4 and his assistant appeared to comply with WPS-B-P-2212-Tc-U5b.

Summary of Conversations:

This QA Inspector, George Goulet, asked each QC if all the welding variables observed by him appeared to comply with the appropriate WPS, including the preheat requirements according to thickness of the thickest member being welded. Each QC showed this QA Inspector, George Goulet, that he was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all he observed did appear to comply.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
